

Friday, 12/12/2008 8:12:18 AM
Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : COWL BRACKET
Job Number : 44034	
Estimate Number : 12754	
P.O. Number :	Part Number : D2127251119
This Issue : 12/12/2008 S.O. No. :	Drawing Number : D212-725-1 PG44
Prsht Rev. : NC	Project Number : N/A
First Issue : 11	Drawing Revision : B
Previous Run : 30983	Material :
Written By : <u>Jan 08.12.12</u>	Due Date : 19/12/2008 Qty: 6 Um: Each
Checked & Approved By :	
Comment : Est Rev:A New Issue 07-02-28 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1000X02000	6061-T6 Bar 1.00 x 2.00
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Comment: Qty.: 0.2835 f(s)/Unit Total : 1.7010 f(s)
6061-T6 Bar 1.0" x 2.0"
Batch: 12110167

Jan 08/12/17

(A)

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
Cut blank 3.250 " long

Jan 08/12/17

(B)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA674 Rev. AA & Dwg D212-725-1 Rev. B

2-Deburr per dwg D212-725-1

B.A 08/12/20

(C)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

B.A 08/12/20

(D)

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

Jan 08.12.22

(E)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COWL BRACKET

Job Number: 44034

Part Number: D2127251119

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 08/12/22

(6)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-L 08/12/22

(6X)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

57124

SS 08/12/22

(X6)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



08/12/22

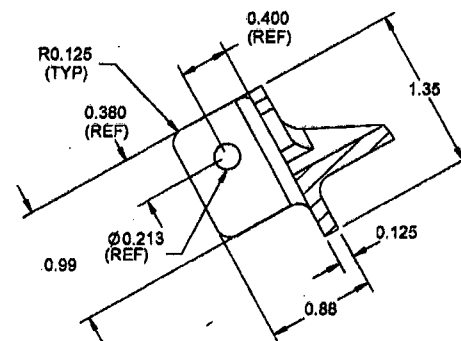
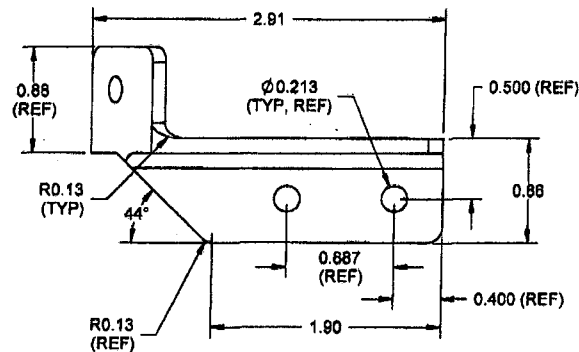
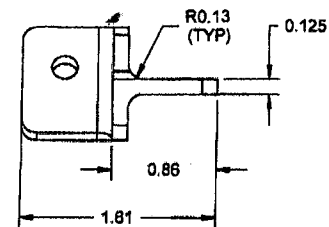
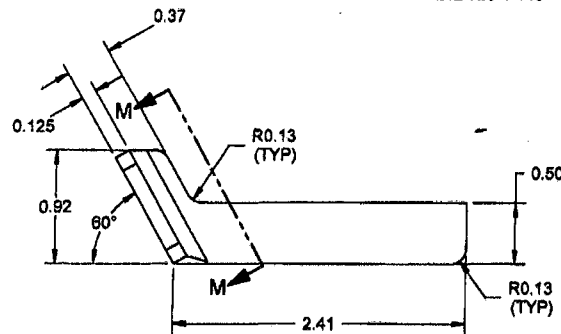
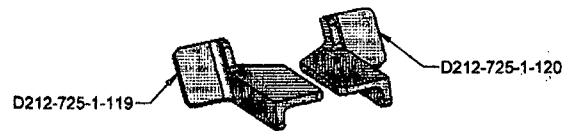
10

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08.12.22




**D212-725-1-119 COWL BRACKET SHOWN
D212-725-1-120 OPPOSITE
(Ø0.213 HOLES TRANSFER FROM AIRCRAFT)**

SECTION M-M

RELEASED
080703

NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-225/8) BAR (REF. DART SPEC. M8061T6B)
- 2) FINISH: ACID ETCH ALODINE 1200 OR 1201 PER MIL-C-5541 AND/OR PRIME & PAINT PER AIRCRAFT MAINTENANCE MANUAL
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

B	07.05.11	ADDED D212-725-1-119-120	
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED DS	APPROVED 	DRAWING NO. D212-725-1	REV. B SHEET 38 OF 44
DATE 07.05.11	TITLE 212S DETAIL PARTS		SCALE 1:1
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DART AEROSPACE LTD		Work Order: 44034
Description: COWL BRACKET		Part Number: D212-725-1-119
Inspection Dwg: D212-725-1 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.37	+/- .030	0.375	✓			
0.125	+/- .010	0.123	✓			
0.92	+/- .030	0.925	✓			
60°	+/- 1/2°	60°	✓			
R 0.13	+/- .030	R 0.130	✓			
2.41	+/- .030	2.41	✓			
0.50	+/- .030	0.500	✓			
0.125	+/- .010	0.127	✓			
0.86	+/- .030	0.864	✓			
1.61	+/- .030	1.614	✓			
2.91	+/- .030	2.906	✓			
0.88	+/- .030	0.877	✓			
44°	+/- 1/2°	44°	✓			
1.90	+/- .030	1.90	✓			
0.86	+/- .030	0.864	✓			
R 0.125	+/- .010	R 0.125	✓			
0.99	+/- .030	0.997	✓			
0.88	+/- .030	0.878	✓			
0.125	+/- .010	0.127	✓			
1.35	+/- .030	1.35	✓			REF
0.887	+/- .010					(REF)
0.400	+/- .010					(REF)
0.0213	+ .005 / - .001					(REF)

Measured by: Y.A	Audited by: [Signature]	Prototype Approval:	N/A
Date: 08/12/20	Date: 08-12-22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

